

Date:  
User:Thursday, 31/07/2008 1:38:34 PM  
Julie Lecocq

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
 Job Number : 40861  
 Estimate Number : 10429  
 P.O. Number :  
 This Issue : 31/07/2008 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : 31/07/2008 Type : MACHINED PARTS  
 Previous Run : 40520  
 Written By :  
 Checked & Approved By : NO 08-8-01  
 Comment : Est: D 04.11.26 Revised Step 7 KJ/JLM

Drawing Name : TUBE ASSEMBLY  
 Part Number : D3304043  
 Drawing Number : D3304 REV. B  
 Project Number : N/A  
 Drawing Revision : B  
 Material :  
 Due Date : 08/08/2008

Qty: 9 Um: Ea

## Additional Product

Job Number:



Seq. #: Machine Or Operation:

Description :

1.0 M304TR0875W065 304 round tube .875 x .065w



Comment: Qty.: 1.9469 f(s)/Unit Total : 17.5222 f(s)

Material: AISI 304/316 SS tubing 0.875" x 0.065" wall  
(M304TR0.875W.065)Batch: 1109007mmf 08/08/22

2.0 BAND SAW BAND SAW



Comment: BAND SAW

1- Cut blank: 22.00" as per Dwg D3304

mmf 08/08/22

3.0 LATHE CONV. CONVENTIONAL LATHE



Comment: CONVENTIONAL LATHE

1- Cut blank: 22.00" as per Dwg D3304

2- Turn as per Dwg D3304

3- Deburr

mmf 08/08/22 SA 08/08/24

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 08/08/24

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SA 08/08/25

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE ASSEMBLY

Job Number: 40861

Part Number: D3304043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Form as per Dwg D3304

Ensure that bend radius does not fall into straight section using DT8756.

2- Drill as per Dwg D3304 using drill Jig D3304-T1

3- Cut tube to length as per Dwg D3304

4- Deburr

FF 08/08/25

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SAD 08/08/25 (2x)

8.0

D33047

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 9.0000 Each(s)

Bracket

Pick:

| Qty | Part Number | Description | Batch    |
|-----|-------------|-------------|----------|
| 1   | D3304-7     | Bracket     | P25067 ✓ |

SP 08-08-27 (2x)

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld bracket as per Dwg D3304 and QSI 004 using DT8775

Pl 08-08-27  
SP 08-08-27 (2x)

10.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

ID 08-08-28 (2x)

11.0

POWDER COATING

POWDER COATING



M106442



(2x)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME: 10:15

OVEN TEMPERATURE: 320°C

FINISH TIME: 10:45

M.F 08/08/28



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Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

08.08.28

(17)

13.0

BLBS0016

PIP PIN



Comment: Qty.: 1.0000 Each(s)/Unit Total: 9.0000 Each(s)

PIP PIN

Pick:

| Qty | Part Number | Description | Batch   |
|-----|-------------|-------------|---------|
| 1   | BLBS-0016   | Pip Pin     | 1103178 |

SAD

08/08/22

(2)

14.0

CBL460

Loop Sleeve



Comment: Qty.: 2.0000 Each(s)/Unit Total: 18.0000 Each(s)

Loop Sleeve

Pick:

| Qty | Part Number | Description | Batch   |
|-----|-------------|-------------|---------|
| 2   | CBL-460     | Loop Sleeve | 1107234 |

SAD

08/08/22

(2)

15.0

CBL1240

Cable



Comment: Qty.: 1.0416 f(s)/Unit Total: 9.3744 f(s)

Cable

Pick:

| Qty   | Part Number | Description | Batch   |
|-------|-------------|-------------|---------|
| 12.5" | CBL-1240    | Cable       | 1103927 |

SAD

08/08/22

(2)

16.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble lanyard and pip pin as per Dwg D3304

Identify as D3304-043

SAD

08/08/22

(2)

17.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/08/20

(2)

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Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N as per Dwg using a permanent fine point marker, then Stock

Location: ST 188

*JS 08/08/28* (2)

19.0

QC21

FINAL INSPECTION/W/O RELEASE



(2)

Comment: FINAL INSPECTION/W/O RELEASE

*08/08/29*

Job Completion



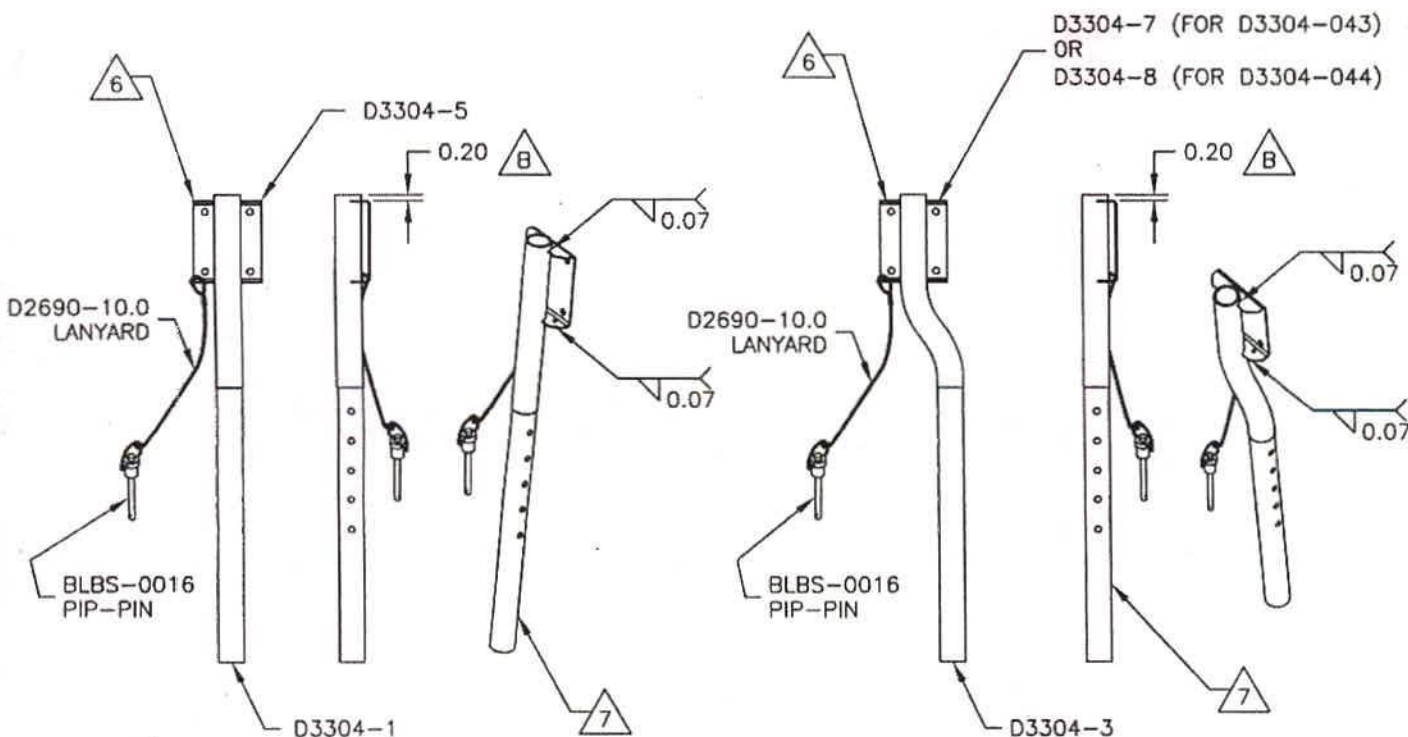
*W 08.08.29*





**DART**

| DESIGN  | RF                 | DRAWN BY                          | RF                 | DART AEROSPACE LTD<br>HAMKESBURY, ONTARIO, CANADA | REV. B       |
|---------|--------------------|-----------------------------------|--------------------|---|--------------|
| CHECKED | <i>[Signature]</i> | APPROVED                          | <i>[Signature]</i> | DRAWING NO.<br>D3304                              | SHEET 1 OF 4 |
| DATE    | 05.07.15           | TITLE                             | TUBE ASSEMBLY      | SCALE   | 1:6          |
| A       | 04.08.18           | NEW ISSUE                         |                    |   |              |
| B       | 05.07.15           | UPDATE DIMENSIONS: ADD D3304-7/-8 |                    |   |              |



**D3304-041 TUBE ASSEMBLY**

**D3304-044 TUBE ASSEMBLY (SHOWN)  
D3304-043 OPPOSITE**

**D3304-041/-043/-044 NOTES:**

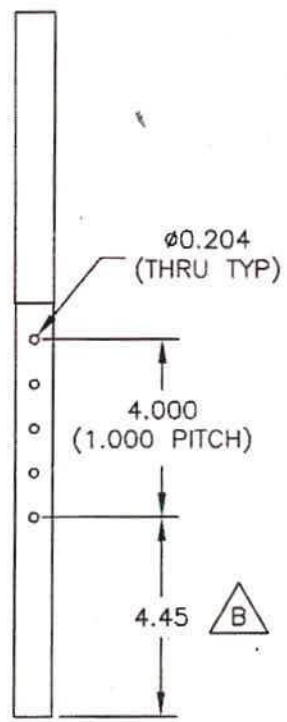
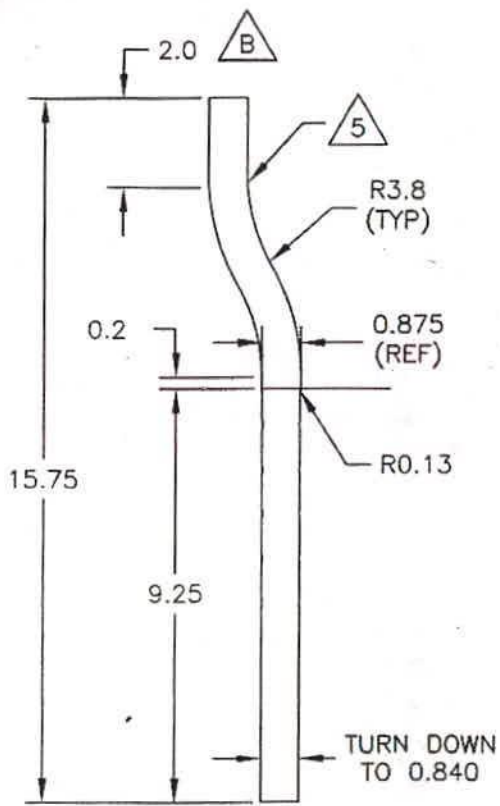
- 1) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 2) WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) IDENTIFY AS INDICATED USING FINE POINT PERMANENT INK MARKER "TCCA-PDA, DART AEROSPACE LTD, P/N D3304-XXX B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA04-11"
- 7) IF BEING ASSEMBLED WITH D3303-041, ADD THE FOLLOWING USING A FINE POINT PERMANENT INK MARKER: "TCCA-PDA, DART AEROSPACE LTD, P/N D412-724-XXX B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA04-11"

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *[Handwritten]*

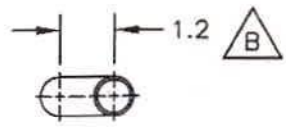
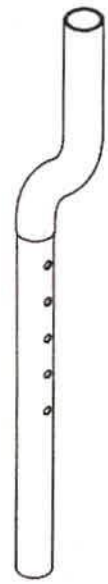
RELEASED  
95-08-11



|                               |                                |   |                        |
|-------------------------------|--------------------------------|---|------------------------|
| DESIGN<br>RF                  | DRAWN BY<br>RF                 | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>[Signature]</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D3304                              | REV. B<br>SHEET 3 OF 4 |
| DATE<br>05.07.15              |                                | TITLE<br>TUBE ASSEMBLY                            | SCALE<br>1:4           |



RELEASED  
05-08-11 *[Signature]*



**D3304-3 TUBE**

**D3304-3 NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE Ø0.875 x 0.065 WALL (REF. DART SPEC M304TRO.875W.065) ENSURE SEAMLESS TUBE IS USED
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) BEND LINES 9.625, 13.375 DIMENSIONS

SHOP COPY  
RETURN TO  
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